Work Ord August-28-13		6004	3612	*106	S004*							Page 1
Item ID: Revision ID:	646.3812	6 4 t B 1	3.361 ² 060 ⁴	Accept	*N900	040	100)*	Setup	Start	*N	S1*
Item Name:	GUSSET BRA	ACKET								Stop	*N	S2*
Start Date: Required Date	8/28/13 e: 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:						
Reference:			_									
Approvals:	Process Pla	an: MLJ	Date: 13-08	79 Tooling:	D _i	ate:			Run	Start Stop	I <i>A</i>	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
646.3800	NC											
110		HAAS CNC VERTICA	L MACHINING #1	0.00					,	-/		lest
110 HAAS 1 HAAS CNC vertice	cal machine #1	Memo 1-Machine		0.00						J		[13/10/03
	•	DWG REV	. <u></u>									
		2- deburr a	nd break all sharp edge	es								
120		QC2- Inspect parts off	machine FAI/FAIB	0.00								1.1
120		Momo		0.00				4	, 	0		/13/10/03

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE			•
											QA Closed:	Date:	
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	CI.					Rework	1		Skid-tube	Crosstube];	Water Jet	Engineering
Part I	۷n					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1 1		noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update	1	1	Large Fab	Composite	1.00,010	Supplier	1
						\ \	_		, <u> </u>				· —
Root					Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_												
Operator			ļ										
Material													
Setup	<u> </u>												
Other	匚												
Process	<u> </u>												
Supplier	L		ļ										
Training	<u> </u>												
Unapproved	<u> </u>	<u> </u>	<u> </u>		,								
							AUI	LT CATE	GORY			,	+
Landi	ing (1			_	General	_	1			7		1
	\vdash	Bending			_	Bend	_	Grain			Ovalized		Pressure/Forced
ļ	\vdash	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa			Over/Under		Temperature/Cure
	\vdash	Cracks			ļ	Broken/Damaged		†	ion incomplete		Part Incorre	<u></u>	Weld
	<u> </u>	Crushed/	Crimped		ļ	Burrs		-1	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination		Mainte		<u> </u>	Part Moved		
}	\vdash	Heat Trea			L	Countersink		Mislabe			Positioned V		1
	1	Inspectio	n Strip in	Tube	i	Cut Too Short	1	Misread	i		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-28-13 1		06004		*106	S004*					Page 2
Item ID: Revision ID: Item Name:	646.3812 GUSSET BR	ACKET		Accept	*N9000	4010C)* s	Stop	*N:	S1* S2*
Start Date: Required Date Reference:	8/28/13 : 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:					
Approvals:		an:		Tooling: SPC (Y/N):	Date:		ŀ	Run Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	and check	Set Up/ Run Hours 0.00	Tool ID T	Cool# Plan Code	Accept Qty		Reject Number	Insp. Stamp
140 *140* Outsource4 Outsource process	- Anodize	2- PRIME A	216-60	00 E #2			<u>C</u> ×	_13/	10/04	1_4
150 *150* Packaging		Receive & Inspect for D	amage & Mat'l Certs	0.00				13/19	128	(Y_

Packaging

											DQA:	Date	e: *
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE			*
											QA Closed	Date	2:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	٠					Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
Root					Descri	ction of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	c	or Non-conformance	Ct	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling				1 1			1						
Operator								_					
Material								.4 7					
Setup													
Other	L			1			ŀ						
Process	L												
Supplier			ł										
Training				1									
Unapproved													
							FAUI	LT CATE	GORY				
Landi	ng (Gear				General		_			_		
		Bending				Bend	L	Grain			Ovalized	L	Pressure/Forced
		Centre N	ot Conce	ntric to C)/S	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte	nance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	'Surge	Other
		Ripples in	n Bend			Drill Holes		Offset				_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio_

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-28-13		6004		*106	004 *						Page
Item ID: Revision ID: Item Name:	646.3812 GUSSET BR.	ACKET		Accept	*N900	040	100)* s	etup Sta	1.7	S1* S2*
Start Date: Required Date Reference:	8/28/13 e: 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:	_				
Approvals:		an:	-	Tooling: SPC (Y/N):		ite:		R	tun Sta St	op *N	R1* R2*
Sequence ID/ Work Center 155 *155* QC Quality Control	ID	Operation Description QC5- Inspect part comp	leteness to step on W/O	Set Up/ Run Houss 0.00 27 9-89 0.00]3]0-0	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packagine		Мето	tock Location: <u>ST53</u>	0.00	AND DEV***			_4×	DAS 28 9-89	13-10	-29

190

QC21- Final Inspection - Work Order Release 0.00

190

0.00 Memo

Quality Control

A/Rm 13/10/29

13/10/29

Page 3

NCR: Yes / No	WORK ORDER NON-CO	NFORMANCE / UPDATE		
	DISPOSITION	AGA	QA Closed: AINST DEPARTMENT/P	ROCESS
Work Order:	Rework	Skid-tube Cross	stube	Water J

Part N	-					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update		Initial	Act	tion	Sign &	•	
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			ł										
Operator													
Material	Ш										ĺ		
Setup													
Other													
Process	Ш						}						
Supplier	Ш												
Training	Ш												
Unapproved			L						<u> </u>				
							AU	LT CATE	GORY				
Landi	$\overline{}$					General	_	,		_	1		- 1
	$\boldsymbol{\vdash}$	Bending			<u> </u>	Bend	<u></u>	Grain			Ovalized	<u>_</u>	Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	\perp	Hardwa			Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	- 1 '	ion Incomplete		Part Incorre	<u> </u>	Weld
		Crushed/	Crimped			Burrs		-	ions Incomplete/U	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs				Contamination		Mainte			Part Moved		
	\vdash	Heat Trea				Countersink		Mislabe	eled	<u> </u>	Positioned V	_	7
		Inspectio	•	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ш	Ripples in				Drill Holes		Offset				·	
	Ш	Torque W			n	Drawing	L	-	Calibration				
		Turning S	equence			Finish	\perp	Out of	Sequence				
	1	Wave/Tu	ist in Tul	ne ne		Folio	1	Outside	Dimensions				

DQA:

Date:

Date:

, Picklist Print

August-28-13 12:27:15 PM

Page 1

Work Order ID:

106004

Parent Item:

646.3812

Parent Item Name:

GUSSET BRACKET

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 4.00

Required Qty: 4.00

Comments.

IPP REV-A NEW ISSUE 12-10-22 ILM VERIFIED DD

Comments.	III KEV.A NEW	1330L 12-10-22	JEIVI VE	KII ILD.DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A0.75X0.75X0.		Purchased	No				f	0.0000		0.4210520	5		-

7075T6 ANGLE .75" X .75" X .060" X .062"W

123947

0,708' /wp /13/10/03

NCR:	Yes	/	No
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WORK ODDED NON-CONFORMANCE / LIDDATE

DQA: _____ Date: ____

NCK: YE	es / No				WORK ORDER NOI4-G	COIVI	ruki	MAINCE / UP	PUATE	QA Closed:	Da	ate:	·	
Work Order	r·			,	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Part No					Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab	⊣	Water Jet d. Eng. Coor	·□	Engineering Quality	
NCR No	o				Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	-	Other	
Root				Descri	ption of work order update	In	itial	Α	ction	Sign &				_
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Des	cription	Date	Verification	on	QC Inspector	_
Doc/Data						1						- 1		
Equip/Tooling	_	1												
Operator	_											ı		
Material														
Setup											-	ŀ		
Other	_													
Process												1		
Supplier												ı		
Training														
Unapproved		l								J				_
						AULT	CATE	GORY						_
Landin				_	General				_	.				
1	Bending			<u> </u>	Bend		Grain		<u> </u>	Ovalized		-	Pressure/Forced	
Ļ	Centre No	ot Conce	ntric to (o/s _	BOM/Route	$\boldsymbol{\vdash}$	lardwa		L	Over/Under		-	Temperature/Cure	
	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorre		\vdash	Weld	
_	Crushed/	Crimped			Burrs	—		ions Incomplete	/Unclear	Part Lost/M	issing		Wrong Stock Pulled	
1	Cuffs			L	Contamination	-		nance		Part Moved				
1	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V	_	\Box		
<u> </u>	Inspectio	-	Tube		Cut Too Short	-	Misreac	i		Power Loss/	Surge		Other	_
1	Ripples in				Drill Holes		Offset							_
L	Torque W			ո _	Drawing			Calibration						_
	Turning S	Sequence	!	ļ	Finish	Щ	Out of S	Sequence						
l	Maye/Tu	vist in Tul	he	1	Folio	1 1	Jutcida	Dimensions						

DART AEROSPACE	LTD	Work Order:	106004
Description:		Part Number:	
Inspection Dwa:	Rev:		Page 1 of 1

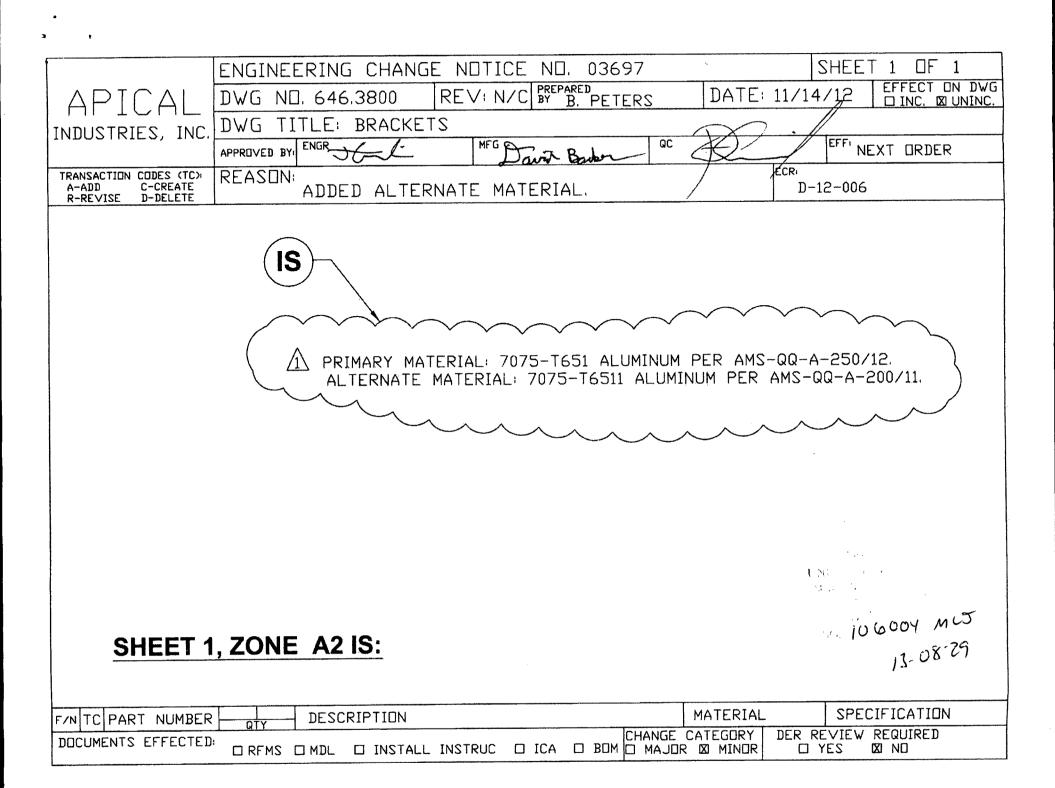
FIRST ARTICLE INSPECTION CHECKLIST

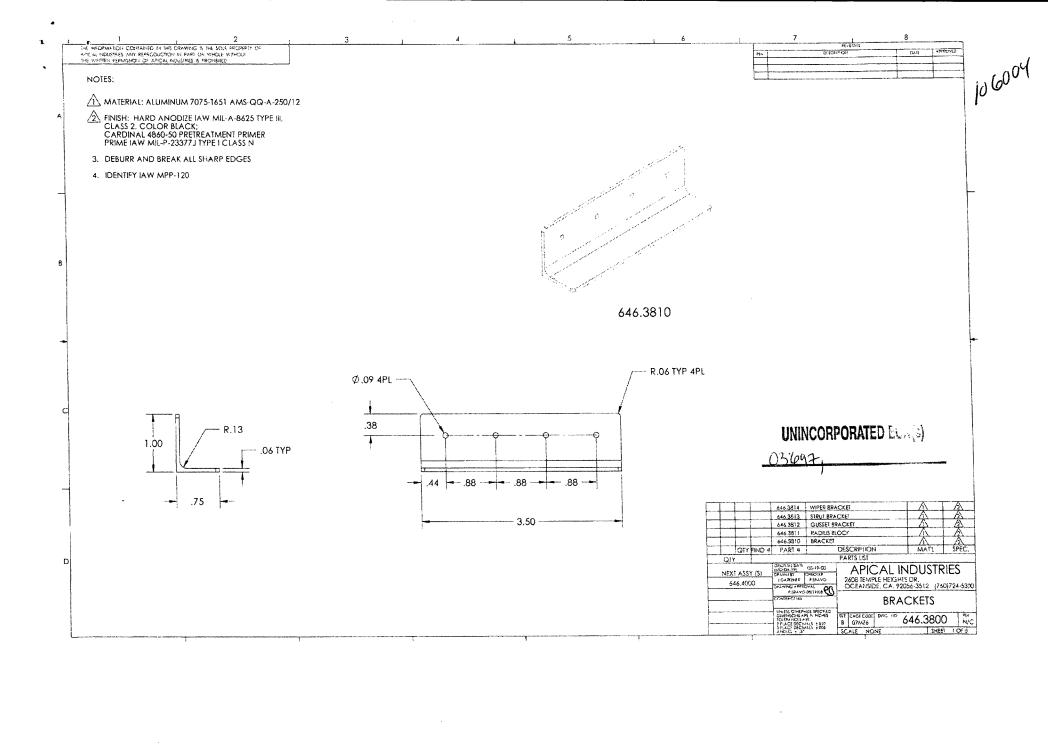
Danis		Actual			Method of	
Drawing Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
2,000	· 0,010	1,999	/		1481-04	Verm
0,3/	+ 0.010				,,,	# : I
0,38	+ 0.010	0,377	/		; , ,	, , ,
1 25					711	, ()
0 0.090	+ 0,010	0,090			111	111
1,25 00,090 10,06	t 0,010	0,062	/			Radius gauge
				 		
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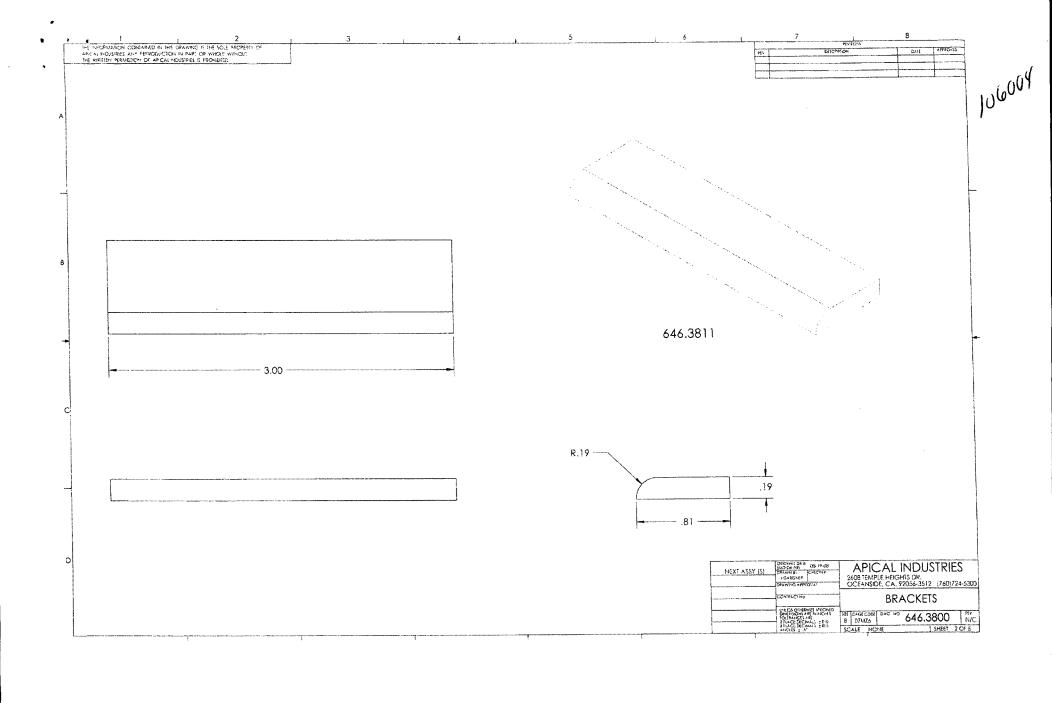
Measured by: Aus P		Audited by:		Preliminary Approval:	
Date:	13/10/03	Date:	13/10/04	Date:	

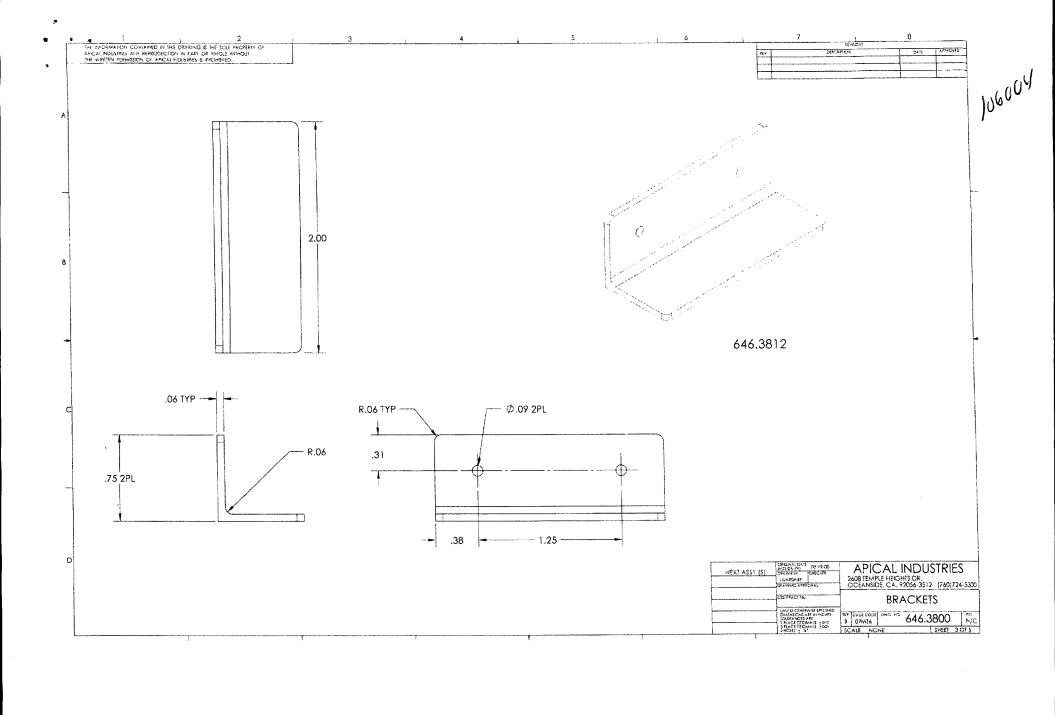
١	Rev	Date	Change	Revised by	Approved
١	E	10.04.14	Added preliminary approval	KJ	

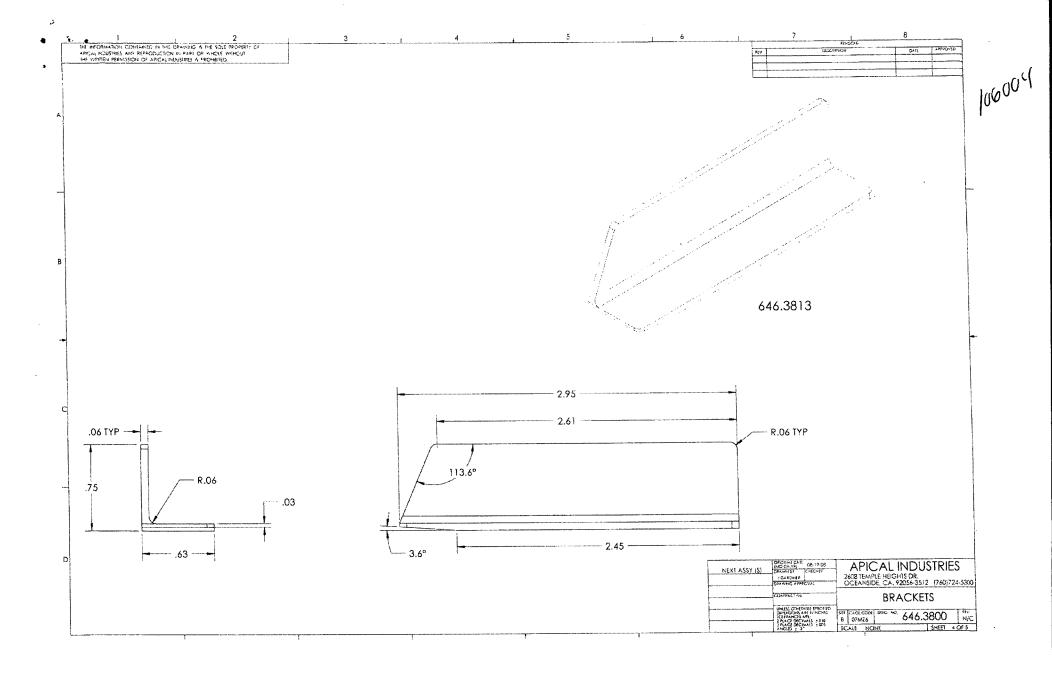
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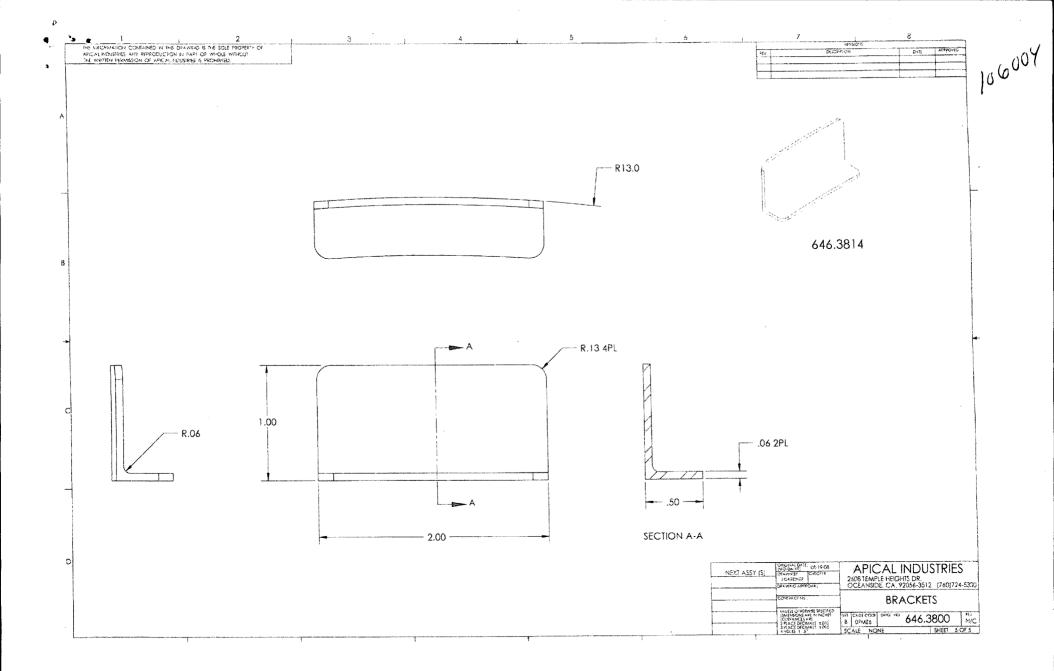














A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62703

Date: 25-Oct-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

612 622 1195

Ph: 613-632-52	200 Fax: 613-632-1185		Ph: 613-632-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Description				
Quantity 1	*		Rev:		
lot	5 PCS 646.2910 (48.00) 12 PCS 646.3610 (6.60) 31 PCS 646.3812 (6.55) (1-6) 8 PCS 646.9811 (27.25)				
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2				
	PRIME MIL-P-23377J TYPE I CLAS	SS N			
	PRICE IS PER PIECE Job: 20130669	PO: 21603	Line:		
	Certificate of Con	formance			
	A.T.G. Industries certifies that all items with all requirements, specifications and	in this shipment a I drawings referer	re in conformance nced in the purchase order.	·	
	ISO 9001 : 2008 REC ATG SALES-2010 TE DATE : 25/10/13	BISTERED ERMS APPLY	·		
	RECEIVER SIGNATURE :				